

PROBLEMS WITH SELF-ADHESIVE LABELLING AND REMEDIES

Label web is shifting ie. The labelling height is not constant

<i>Possible Cause</i>	<i>Possible Remedy</i>
Label web tension not uniform <ul style="list-style-type: none"> • Drive roller or deflections are soiled. • Peeling plate is rubbing against the container. 	<ul style="list-style-type: none"> • Clean drive roller and deflection rollers • Re-adjust support until peeling plate has the right clearance from the container.
Spacer rings have not been set <ul style="list-style-type: none"> • No positive guidance of label web possible. 	Adjust spacer rings so as to ensure accurate label web travel.
Rollers, peeling plate, deflection rollers incorrectly adjusted.	Check settings with high-precision spirit level (take 2 measurements at rollers, peeling plate and deflection roller each offset by 90°). Only then perform complete adjustment using support spindles (e.g. with conical bottle).
Label web reel is poorly wound or deformed	Fit new label web reel
Peeling plate is not at right angles to the web's direction of travel	Re-adjust peeling plate

Label carrier web tears

<i>Possible Cause</i>	<i>Possible Remedy</i>
Label carrier web has not been correctly inserted, is running outside the guide aids.	Insert label carrier web as shown in threading diagram
Label web tension is not uniform over the entire label web width.	Re-adjust peeling plate
Label carrier web exhibits random tears, cutting or is poorly glued	Perform reel change
Pressure of the brake brush is too strong	Reduce brake brush pressure
Label web loop in the feed unit is not being properly formed.	Close flap with counter-pressure roller. Re-adjust or clean photo-cell and mirror. Replace feed unit motor.
Rewind unit is too slow (label web is too loose)	Correct speed
"Label web tear monitor" switch is incorrectly set	Set correctly

Label is wrongly positioned

<i>Possible Cause</i>	<i>Possible Remedy</i>
Label applicator is set too high or too low	Set label applicator to requisite label height.
Peeling plate is not set at 15° to the dispensing surface.	Check setting at the peeling plate.
Container is soiled, wet or misted -> label does not adhere.	Use only clean, dry containers
Label is placed in the wrong position	Re-adjust label stop photo –cell.
No label on the carrier web.	File complaint with the label manufacturer.
Roll-on unit is not close enough to the peeling plate.	Correct setting of the roll-on unit.
Peeling plate is too far away from the container.	Use the support to bring the peeling plate as close as possible to the container, but not rubbing against it!
Support clamps not tightened.	Fix all clamps
Labels are not being detached at the peeling plate (adhesive force of labels too great)	Reduce peeling plate radius. Store label rolls in 55% RH, 15° - 25°C.
Glue carry-over at the peeling plate from label to container.	Clean peeling plate.
Reflector photo-cell or label stop photo-cell is incorrectly adjusted.	Check setting, re-adjust if necessary.

There are irregular faults during labelling

<i>Possible Cause</i>	<i>Possible Remedy</i>
Photo-cell for label stop soiled or incorrectly adjusted.	Re-adjust and clean photo-cell. Label web has to stop precisely!
Dimensional and shape differences among containers.	Use only container for which the machine has been adjusted.
Space between labels not constant, or cutting register mark not constant.	Perform reel change, or file complaint with the label manufacturer.
Label has been predispensed too far.	Correct setting (max. predispending approx. 1/3 of label length)
No impression of driven roller visible on empty web.	Fault in drive roller unit, check basic setting.
Handling parts incorrectly installed.	Fit handling parts to suit particular container involved (note colour or container designation)
Wear and tear at the counter-pressure roller	Install new counter-pressure roller.
Rewind unit pulls empty web in jerks	Set proximity switches in rewind unit so that dancer drum

	does not bank against stop screws.
Container moist, misted, soiled	Eliminate cause. Surface treatment with flame or arc

There is label wrinkling

<i>Possible Cause</i>	<i>Possible Remedy</i>
Dispensing speed is too high or too low.	Re-adjust dispensing speed.
Label is being predisensed too far or too little.	Correct setting (max. predisensing 1/3 of label length)
Label is not being rolled on immediately after transfer.	Roll-on unit soiled or incorrectly adjusted.
Label is not being evenly stuck or rolled on	Roll-on unit soiled or incorrectly adjusted
Container is not level at labelling surface.	Use softer plastic labels
Label is being prematurely attracted to the container due to static charging	Use static eliminator.
Peeling plate incorrectly adjusted	Set flatter angle of incidence to peeling plate.

There are bubbles under the label.

<i>Possible Cause</i>	<i>Possible Remedy</i>
Labelling surface is uneven.	File complaint with the container manufacturer.
Container is soiled.	Use only clean, dry, dust-free containers.
Label is being predisensed too far.	Correct setting of predisensing unit.
Dispensing speed is not correct.	Re-adjust dispensing speed.
Static charging.	Surface treatment with flame or arc.
Wipe down pressure.	Adjust pressure and carry out water spray test. Identify obvious lack of contact through back of container.

The label doesn't stick to the bottle

<i>Possible Cause</i>	<i>Possible Remedy</i>
Label pressure on applicator not correct.	Labelling pressure requires group applicator adjustment.
Dispenser on bottling line not correct.	Check the synchronization of the dispenser and the bottling line.
Adhesive is not well adapted to the bottle surface treatment.	Ensure correct adhesive specification.
Printed labels have exceeded their date of expiry.	Labels recommended to be used within 12 month, from receipt date.

The label stays on the backing

<i>Possible Cause</i>	<i>Possible Remedy</i>
Plate system/web tension not well adjusted.	Adjust peeling plate
Badly set dispensing tool.	Adjust dispensing tool.
Dispensing tool not well adapted.	Adjust dispensing tool.
Label shape not adapted to the labelling machine.	Check specifications.
Backing defect due to poor storage conditions.	Ensure correct handling and storage.
Release is too high.	Check specifications.
Die cut too heavy.	Reject labels contact label provider
Lack of silicon on the backing.	Reject labels, contact label provider.

Pre-Dispensing problem

<i>Possible Cause</i>	<i>Possible Remedy</i>
Release too low.	Check Label specification.
Plate system/web tension not well adjusted.	Readjust peeling plate.
Label with very little shape might be wound with the face side in, which is not recommended.	Not recommend, change wind direction.
Printed labels have exceeded their date of expiry.	Labels recommended to be used within 12 month

	from receipt date.
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